

Work Order ID 65567

January 19, 2011 2:35:26 PM



Page 1

Item ID: D350-607-041A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D350-607-1	A

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-041A
CHG001

81122101

After BG 11-01-31 (1)

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/1/31 SP (12)

120 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D350-607 / DSI 9473
Seal support gusset seam with white sikaflex-291
Batch: M116040
Expiry date: 02/2011

EB 11/02/01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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January 19, 2011 2:35:28 PM



Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Packaging	0.00	Rev I			11/2/11			
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-607-041A Location: BK								
170 	QC21- Final Inspection - Work Order Release	0.00				11/02/02			
QC	Memo	0.00							
Quality Control									

pl 11-02-1
(1)

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January 19, 2011 2:35:10 PM

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 		Purchased	No			110	Each	28.0000	4	4			
NUT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		28							
					116075	28							
AN3C11A 		Purchased	No			110	Each	72.0000	4	4			
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		72							
					112255	2							
					112969	20							
					116590	50							
AN3C16A 		Purchased	No			110	Each	59.0000	4	4			
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		59							
					111193	8							
					111425	5							
					115835	46							

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Picklist Print

January 19, 2011 2:35:10 PM

Work Order ID: 65567

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

D3953-1
Gas Spring Bracket

Manufactured No

110 Each

31.0000

2



1.1.131

2

1.1.131

2

1.1.131

2

Location

Loc Qty

Loc Code

ST101

31

52756

3

53760

28

D3953-11
Gas Spring Spacer

Manufactured No

110 Each

13.0000

2



1.1.131

2

1.1.131

2

1.1.131

2

Location

Loc Qty

Loc Code

ST095

12

65051

12

ST324

1

52767

1

D3953-13
Gas Spring Spacer

Manufactured No

110 Each

29.0000

2



1.1.131

2

1.1.131

2

1.1.131

2

Location

Loc Qty

Loc Code

ST101

29

52761

29

D3953-3
Gas Spring Stud, Lid

Manufactured No

110 Each

10.0000

2



1.1.131

2

1.1.131

2

1.1.131

2

Location

Loc Qty

Loc Code

ST096

10

65052

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

D3953-5

 Gas Spring Stud, Base

Manufactured No

110 Each

8.0000

2



11/13/11

Location

Loc Qty

Loc Code

ST101

8

53434

1

53758

7

D3953-7

 Spring Spacer

Manufactured No

110 Each

13.0000

2



11/13/11

Location

Loc Qty

Loc Code

ST096

11

65053

11

ST101

1

57758

1

ST103

1

65336

1

D3953-9

 Gas Spring Washer

Manufactured No

110 Each

26.0000

4



11/13/11

Location

Loc Qty

Loc Code

ST096

17

65136

17

ST100

7

64450

7

ST103

2

60008

2

W/O:		WORK ORDER CHANGES					
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January 19, 2011 2:35:11 PM

Page 4

Work Order ID: 65567

Parent Item: D350-607-041A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

D3969-1 Manufactured No

110 Each

31.0000

2



Spring (Basket Lid)



2
11/1/31

Location

Loc Qty

Loc Code

ST272

31

52889

22

53759

9

MS21043-3 Purchased No

110 Each

1,677.000

8



Nut



2
8
11/1/31

Location

Loc Qty

Loc Code

FG

76

.103691

76

ST301

1601

112314

1601

MS24665-2-12 Purchased No

110 Each

75.0000

4



COTTER PIN



4
11/1/31

Location

Loc Qty

Loc Code

ST309

75

111499

75

NAS1149C0332R Purchased No

110 Each

4,752.000

8



Washer



✓
8
11/1/31

Location

Loc Qty

Loc Code

ST297

4752

115000

125

115698

35

116025

1592

116304

3000

8

January 19, 2011 2:35:12 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 5

January 19, 2011 2:35:12 PM

Work Order ID: 65567



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Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R Purchased No

110 Each 204.0000 4



Washer



4
11/13/10

Location

Loc Qty

Loc Code

ST297

204

114292

50

114742

63

116304

91

4

D350-607-241 CH9001 Manufactured No

140 Each 0.0000 1



Basket Clamp Assembly



1
B 65145 11/21/10

D2022-101 Manufactured No

110 Each 64.0000 2



Spacer



2
11/13/10

Location

Loc Qty

Loc Code

ST504

64

50746

23

52325

10

63318

31

2

D2221 Manufactured No

110 Each 0.0000 1



350 Basket Base



B 65570 11/21/10

D2258-200 Manufactured No

110 Each 10.0000 1



Placard 200lb



1
11/12/10

Location

Loc Qty

Loc Code

ST505

10

64284

10

1

D2512 Manufactured No

110 Each 0.0000 1



Basket Lid 205/350



B 65568 11/21/10

January 19, 2011 2:35:12 PM

Shop Packet Print

Page 5

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Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

D2530



Handle Weldment

Manufactured No

110

Each

5.0000



1

11/1/31 SP

Location

Loc Qty

Loc Code

ST506

5

64443

5

D2535



Spring

Manufactured No

110

Each

58.0000



2

11/1/31 SP

Location

Loc Qty

Loc Code

ST504

58

58331

18

64280

40

D2537



Bushing

Manufactured No

110

Each

30.0000



2

11/1/31 SP

Location

Loc Qty

Loc Code

ST504

30

64064

30

D2931



Bumper

Manufactured No

110

Each

738.0000



2

11/1/31 SP

Location

Loc Qty

Loc Code

ST504

738

46064

738

11/1/31 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 1/20/11

Required Date: 2/04/11


Start Qty: 1.00


Required Qty: 1.00

AN3-16A Purchased No 110 Each 106.0000 2  11/13/11


Bolt

Location	Loc Qty	Loc Code
ST352	106	
114752	56	
116419	50	

AN4-7A Purchased No 110 Each 111.0000 2  11/13/11



Bolt


Location	Loc Qty	Loc Code
ST356	111	
113226	61	
115373	50	

AN5-17A Purchased No 110 Each 148.0000 4  11/13/11


Bolt

Location	Loc Qty	Loc Code
ST339	148	
116003	48	
116590	100	

MS20600-AD4W3 Purchased No 110 Each 1,339.000 2  11/13/11


Cherry Rivets

Location	Loc Qty	Loc Code
ST321	1339	
107939	754	
111636	585	

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Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No

110 Each

30.0000

2

2



Washer



M116304 1/1/31P

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

AN960JD516 NAS1149D0563J Purchased No

110 Each

34.0000

4

4



Washer



M114742 1/1/31P

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

AN960JD8 NAS1149DN832 Purchased No

110 Each

10.0000

2

2



Washer



M116513 1/1/31P

Location

Loc Qty

Loc Code

ST347

10

105059

10

W/O:		WORK ORDER CHANGES					
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January 19, 2011 2:35:21 PM

Page 9

Work Order ID: 65567



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Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased No

110 Each

3,171.000 10

10



Nut



1/1/31 SP

Location

Loc Qty

Loc Code

ST300

3171

114784

9

115835

662

116391

900

116540

800

116549

800

10

MS21042L4

Purchased No

110 Each

4,462.000 2

2



Nut



1/1/31 SP

Location

Loc Qty

Loc Code

ST300

4462

1123143

2

115589

10

115621

85

116188

3500

116548

865

2

MS21042L5

Purchased No

110 Each

1,293.000 4

4



Nut



1/1/31 SP

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1267

115156

5

115594

500

116104

66

116105

496

116548

200

4

January 19, 2011 2:35:21 PM

Shop Packet Print

Page 9

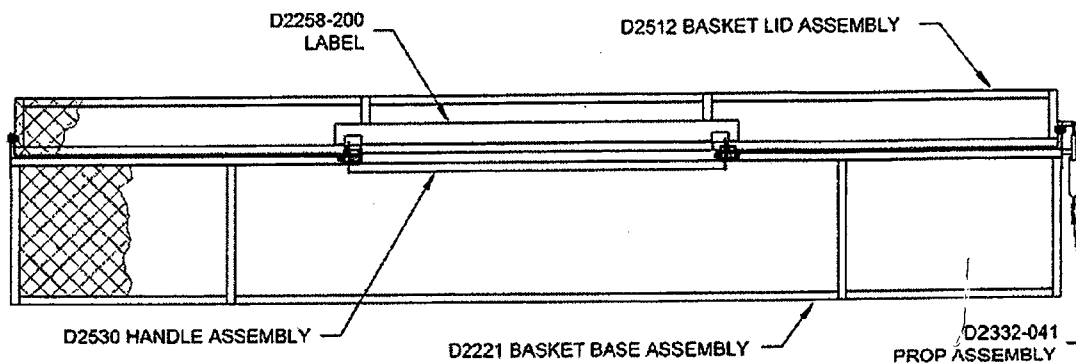
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

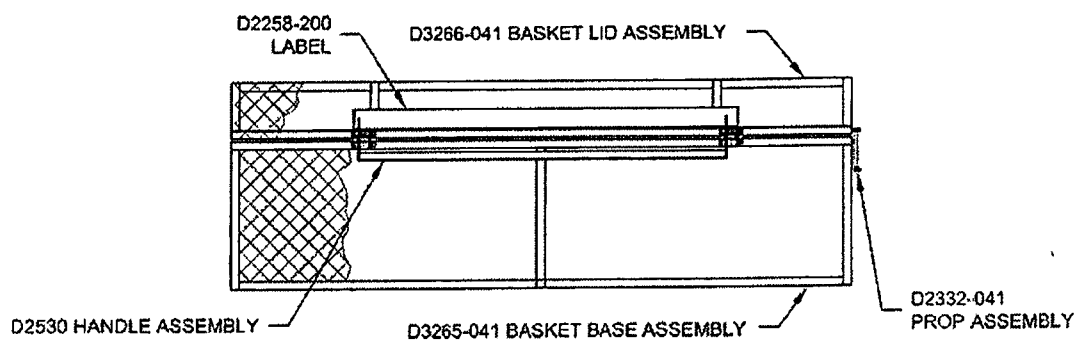
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

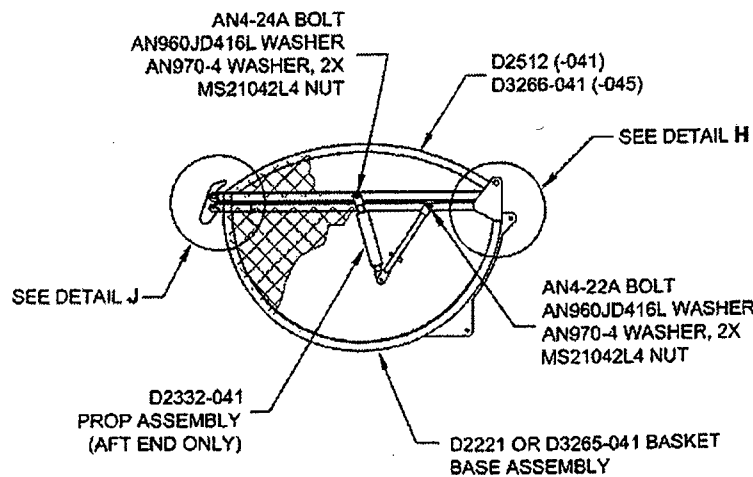
NOTE: Date & initial all entries



D350-607-041 HELI-UTILITY- BASKET™



D350-607-045 HELI-UTILITY- BASKET™

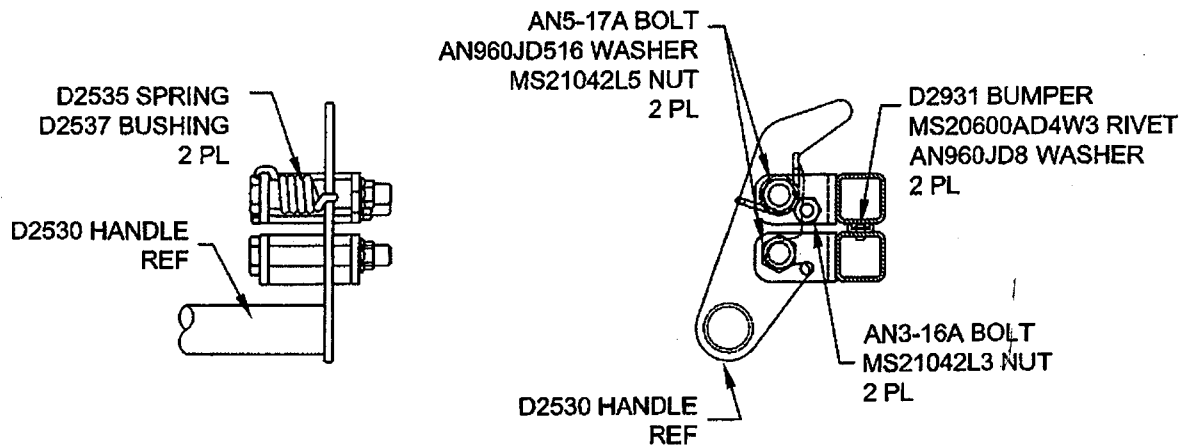


VIEW C-C
PROP ARM DETAIL

FIGURE 25-4 - D350-607-041/-045 HELI-UTILITY BASKET™
(LH Installation Shown, RH Opposite)

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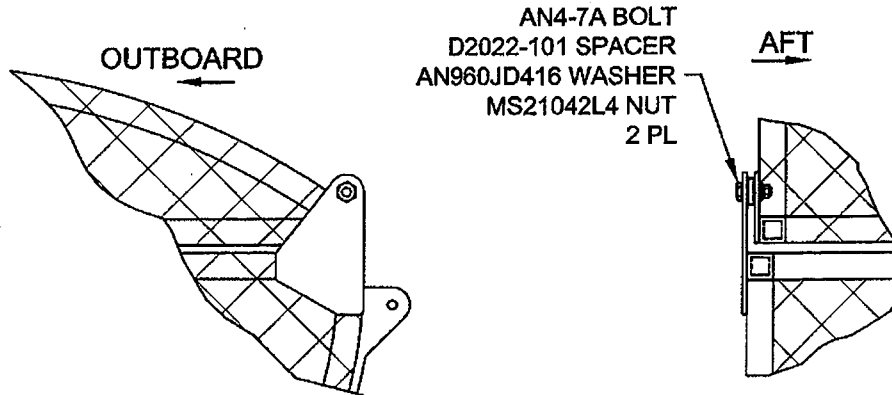
25-00-00



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

FIGURE 25-6 - D350-607-041/-041A/-043/-043A/-045/-045A/-047/-047A HELI-UTILITY BASKET™
HINGE AND HANDLE DETAILS

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25-00-00

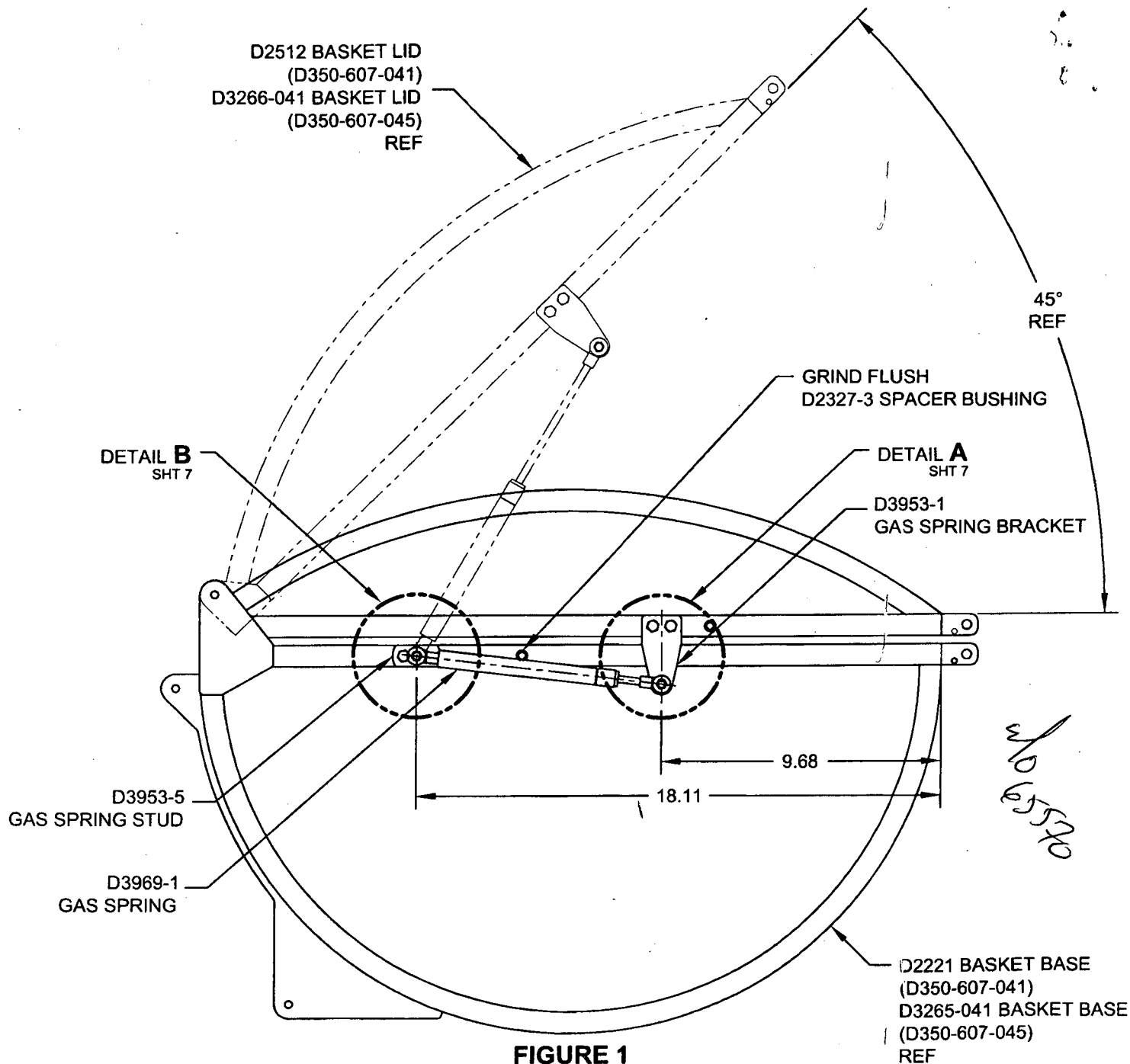


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.11.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS
DRAWN	AJS
CHECKED	<i>[Signature]</i>
MFG. APPR.	N/A
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	09.11.11

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
DSI 9473 SHEET 5 OF 8
TITLE SCALE
AUTOMATIC LID OPENER INSTL NTS

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FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM AS FOLLOWS:

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

NOTE: ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

NOTE: THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A $\frac{9}{16}$ OPEN END SPANNER / WRENCH.

NOTE: WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
- 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

1065570

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	09.11.11
CERT. NO.:	SH94-14
ISSUE NO.:	4

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	DSI 9473	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
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